

Work Order ID 83039

83039

Page 1

April-12-12, 1:00:36 PM

Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 12/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3274	D
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100	DOCUMENT CONTROL	0.00
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100

DC	Memo	0.00
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Document Control Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 26/04/2012 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M120164

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

SAD 12-04-25

SAD 12-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00

114

QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00

116

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

7/6 12-5-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC7-Inspect Chemical Conversion Coat 0.00

130

QC Memo 0.00

Quality Control

① SAD 12-05-01

150 0.00

150

Skidtubes Memo 0.00

Skidtubes 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/RSikaflex-291 7/12/22

Sikaflex expire date: 2023-01-04

Start: 12-04-01 Time: 5:00

Finish: 12-05-01 Time: 3:00

(Adhere for 12 hours)

CF 12-5-1
SAD 12-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 5

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Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00


160

QC

Memo

0.00

Quality Control

 12-5-2

170

Skidtubes

0.00

170

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

- DE 12/05/02

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

SAD 12-05-04

W/O:		WORK ORDER CHANGES					
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Page 6

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Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00				1	0	BE	12/05/07
Quality Control									
190		0.00							
190									
Skidtubes	Skidtubes	0.00							
Skidtubes	Memo								
	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod <u>11/20/04</u>								BE 12/05/08
	3-Grind cross bolt welds flush as per Dwg D3274.								
	4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.								

OK/CC 12-5-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 7

April-12-12 1:00:36 PM

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 12/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00

220

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

NG 12-5-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 8

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1

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Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

230

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

250

HandFinishing

0.00

250

HandFinish

Hand Finishing

Memo

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.
A/RN/ALPS-3 111145962-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a
A/RSikaflex-291 111121221Sikaflex expire date: 13/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 9

April-12-12 1:00:37 PM

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1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 *260* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Nut Plate & Inserts	0.00 0.00				(1)			MM 12.05.11
270 *270* HandFinish Hand Finishing	HAND FINISHING RESOURCE #1 Memo 1-Install wearpads & gaskets as per Dwg D3274. 2-Install ring as per Dwg D3274 A/RSikaflex-291 11/12/11 Sikaflex expire date: 11/14 3-Inspect for foreign objects as per QSI 024 4-Spray inside of tube on both sides of web with LPS-3 A/R LPS-3 Batch: 11/14/11 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/RSikaflex-291 11/12/11 Sikaflex expire date: 11/14	0.00 0.00				1			MM 11/05/11

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Work Order ID 83039***83039***

Page 10

April-12-12 1:00:37 PM

Item ID: D206-642-541

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC5- Inspect part completeness to step on W/O

0.00

280

QC

Memo

0.00

Quality Control

8/17/14

290

Identify as per dwg & Stock Location: _____

0.00

290

Packaging

Memo

0.00

Packaging

PPP 83039

12/4/12 (1)

300

QC21- Final Inspection - Work Order Release

0.00

300

QC

Memo

0.00

Quality Control

12/16/11

ME
12-05-08

W/O:		WORK ORDER CHANGES					
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Picklist Print

April-12-12 1:00:41 PM

Page 1

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190		Manufactured	No			110	Each	114.0000	1	1			
D2600-1-190									**			SAD 12-04-25	
Extrusion Round 3" 206													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				HALL			45						
				69622			45						
				LG			69						
				76912			69						
D3285-1		Manufactured	No			110	Each	53.0000	1	1			
D3285-1									**			BE 12-04-26	
Cap													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				LG002			53						
				52511			6						
				52647			47						
D3282-041		Manufactured	No			150	Each	9.0000	1	1			
D3282-041									**			SAD 12-05-01	
Float Web (206L/407)													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				LG			9						
				77498			1						
				80837			8						

W/O:		WORK ORDER CHANGES					
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April-12-12 1:00:41 PM

Page 2

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D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

1,108.000

12

12

D2649

Cross Bolt Spacer

**

BE 12/05/07

Location

Loc Qty

Loc Code

LG

769

77574

2

79502

65

79503

399

79564

296

79565

7

LG001

339

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

212

12

D3275-1

Manufactured No

190

Each

201.0000

12

12

D3275-1

Crossbolt Spacer

**

BE 12/05/07

Location

Loc Qty

Loc Code

LG

103

80184

103

12

LG002

98

66930

94

74437

4

April-12-12 1:00:41 PM

Shop Packet Print

Page 2

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Page 3

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Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1,382.000

2

2

CR3212-4-03

Cherry Rivet

**

YH 12/05/11

Location

Loc Qty

Loc Code

FP002

394

114859

394

ST331

988

110139

2

119017

986

Y2

D3415-041

Manufactured

No

250

Each

14.0000

1

1

D3415-041

Nut Plate

**

YH 12/05/11

Location

Loc Qty

Loc Code

ST042

14

67605

14

X1

CCR264SS3-3

Purchased

No

250

Each

497.0000

2

2

CCR264SS3-3

Cherry Rivet

**

YH 12/05/11

Location

Loc Qty

Loc Code

ST331

497

113973

2

117849

109

119017

386

X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:00:41 PM

Page 4

Work Order ID: 83039

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

83039

D206-642-541

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

6.003.000

78

78

AI S4-1032-130

Insert

**

HL 12/05/11

Location

Loc Qty

Loc Code

ST280

205

119084

116

120671

89

ST281

2798

120807

798

120837

2000

ST282

3000

121269

3000

x30

x48

D3536-15

Manufactured

No

270

Each

34.0000

1

1

D3536-15

Gasket

**

HL 12/05/11

Location

Loc Qty

Loc Code

FP002

34

73318

16

80333

4

81343

14

x1

D3536-23

Manufactured

No

270

Each

21.0000

1

1

D3536-23

Gasket

**

HL 12/05/11

Location

Loc Qty

Loc Code

FP002

21

74510

1

80334

20

083377

x1

April-12-12 1:00:41 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:00:41 PM

Page 5

Work Order ID: 83039

83039

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-35	Manufactured	No	270	Each	47.0000	1	1
D3536-35						**	<u>ML 12/05/11</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	47	
80335	11	
81340	12	<u>xl</u>
82065	24	

D3536-39	Manufactured	No	270	Each	24.0000	1	1
D3536-39						**	<u>ML 12/05/11</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	12	
82252	12	
FP002	12	
<u>73317</u>	12	<u>xl</u>

D3535-15	Manufactured	No	270	Each	31.0000	1	1
D3535-15						**	<u>ML 12/05/11</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	31	
74512	6	
<u>80328</u>	12	<u>xl</u>
81354	13	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:00:41 PM

Page 6

Work Order ID: 83039

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

83039

D206-642-541

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-35 Manufactured No

270 Each

44.0000 1 1

D3535-35

Wearshoe

**

HL 12/05/11

Location

Loc Qty

Loc Code

FP001

44

67598

1

70815

1

78873

13

79849

1

81358

13

82064

15

VI

D3535-39 Manufactured No

270 Each

18.0000 1 1

D3535-39

Wearshoe

**

HL 12/05/11

Location

Loc Qty

Loc Code

FP001

18

69759

1

73316

5

74513

12

VI

D3535-23 Manufactured No

270 Each

15.0000 1 1

D3535-23

Wearshoe

**

HL 12/05/11

Location

Loc Qty

Loc Code

FP001

15

74508

1

80330

14

VI

381355

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:00:41 PM

Page 7

Work Order ID: 83039

83039

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No

270

Each

33.0000

1

1

D3537-3

Wearpad

**

JL 12/05/11

LocationLoc QtyLoc Code

FP002

33

78836

24

80338

9

XL

D3537-1 Manufactured No

270

Each

42.0000

9

9

D3537-1

Wearpad

**

JL 12/05/11

LocationLoc QtyLoc Code

FG

10

79833

10

FP002

32

69817

5

80337

4

81361

23

B81362

X9

AN960C10L Purchased No

270

Each

0.0000

80

80

***AN960C10I ***

washer

**

11121509

(x80) JL 12/05/11

AN960C416 Purchased No

270

Each

0.0000

1

1

AN960C416

washer

**

11119097

(x1) JL 12/05/11

April-12-12 1:00:41 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:00:41 PM

Page 8

Work Order ID: 83039

83039

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,016.000

2

2

D3672-1

Phenolic Washer

**

yl 12/05/11

Location

Loc Qty

Loc Code

FP001

34

~~121556~~

66821

34

ST060

982

72229

4

76277

478

x2

80369

500

AN3C4A

Purchased

No

270

Each

2,864.000

80

80

AN3C4A

BOLT

**

yl 12/05/11

Location

Loc Qty

Loc Code

ST350

2864

121556

120187

1798

x54

120521

28

x26

120769

38

121205

1000

AN4C5A

Purchased

No

270

Each

235.0000

1

1

AN4C5A

BOLT

**

yl 12/05/11

Location

Loc Qty

Loc Code

ST355

235

112243

152

x1

119017

83

April-12-12 1:00:41 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:00:41 PM

Work Order ID: 83039

83039

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

80.0000

1

1

D2646

Aft Cap

**

HL 12/05/12

Location

Loc Qty

Loc Code

FP002

80

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

22

79500

1

79562

41

X1

D3413-1

Manufactured No

270

Each

48.0000

1

1

D3413-1

Ring

**

HL 12/05/12

Location

Loc Qty

Loc Code

ST420

16

79233

16

ST464

32

76754

22

80224

10

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

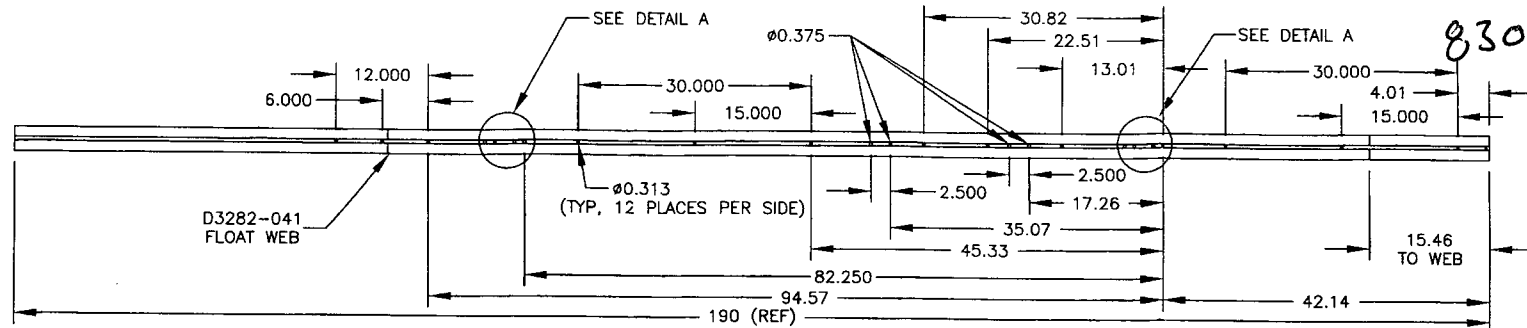
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 03035 MJS
12/01/12

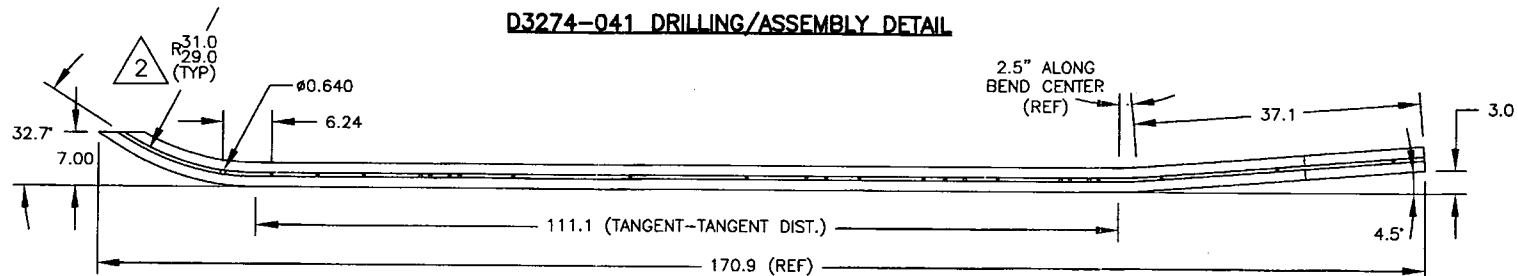
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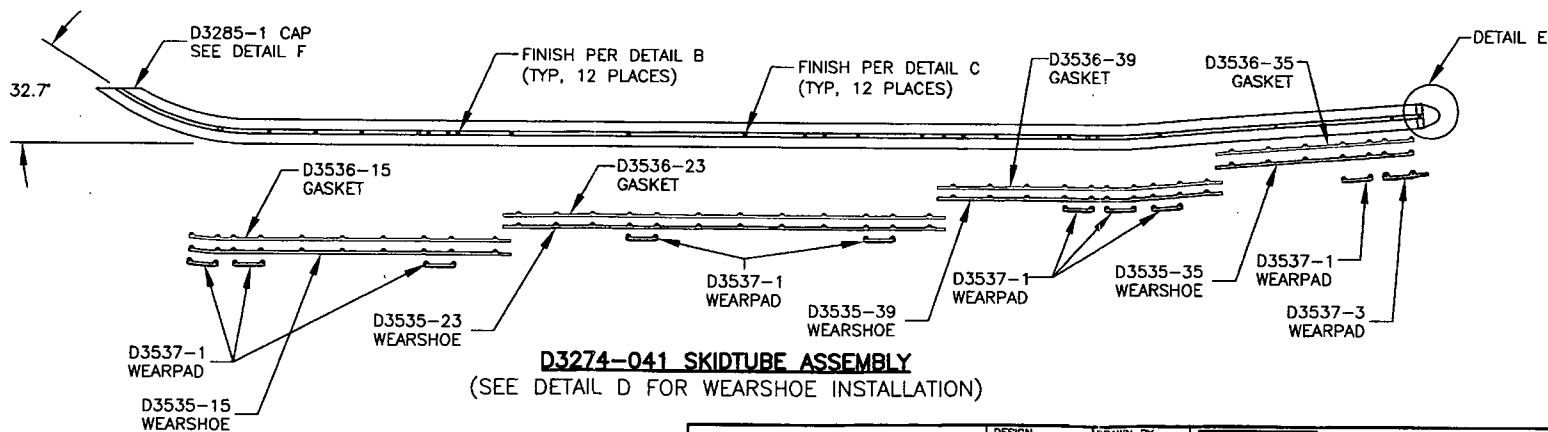
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

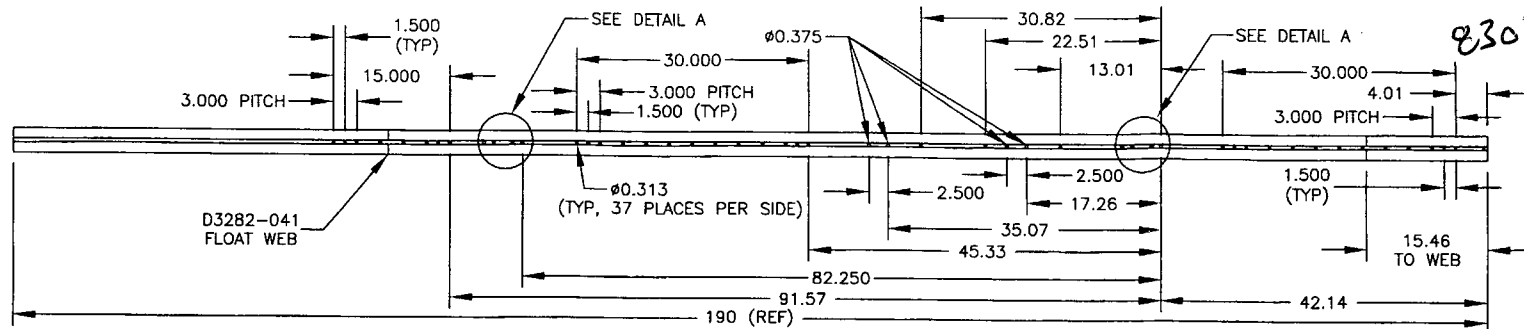
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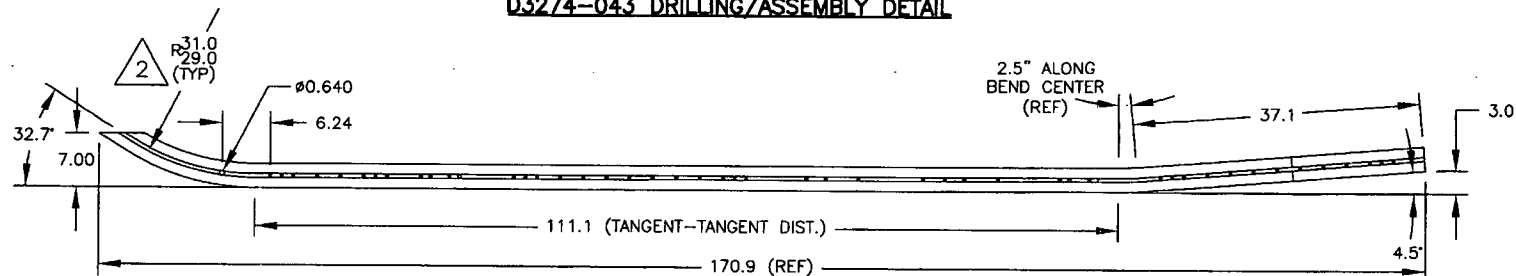
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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	
DATE	06.12.19	DRAWING NO.	D3274	REV. D
TITLE				SHEET 2 OF 4
SKIDTUBE ASSEMBLY				SCALE 1:15

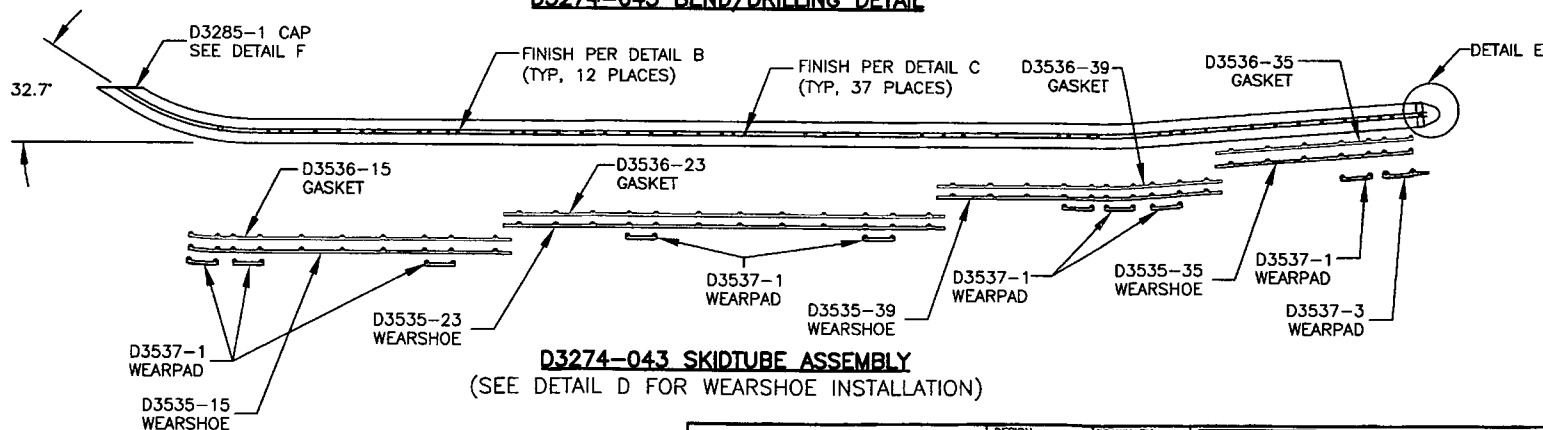
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

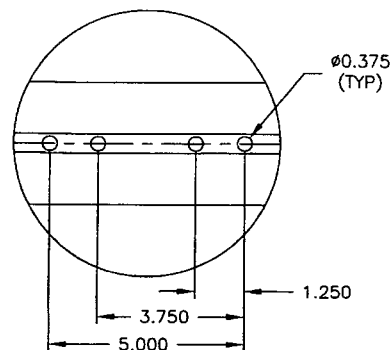
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

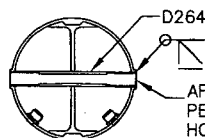
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		DATE	06.12.19			TITLE	SKIDTUBE ASSEMBLY
						REV. D	SHEET 3 OF 4
						SCALE	1:15

DETAIL A: DRILL DETAIL

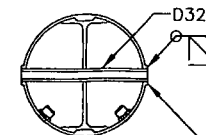


DETAIL B FOR Ø0.375 HOLES ONLY



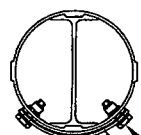
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E

- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291
- D2646 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

0.400

DETAIL F: END FINISHING DETAIL

- CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3
- CR3212-4-03 RIVETS (2 PLACES)
INSTALL WITH LPS-3
- D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR
- D3413-1 RING
- D3285-1 CAP (REF)
- 1.0
REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.
- ORIENTATION
OF D3415-041

DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED

07.02.12

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		REV. D SHEET 4 OF 4 SCALE 1:3

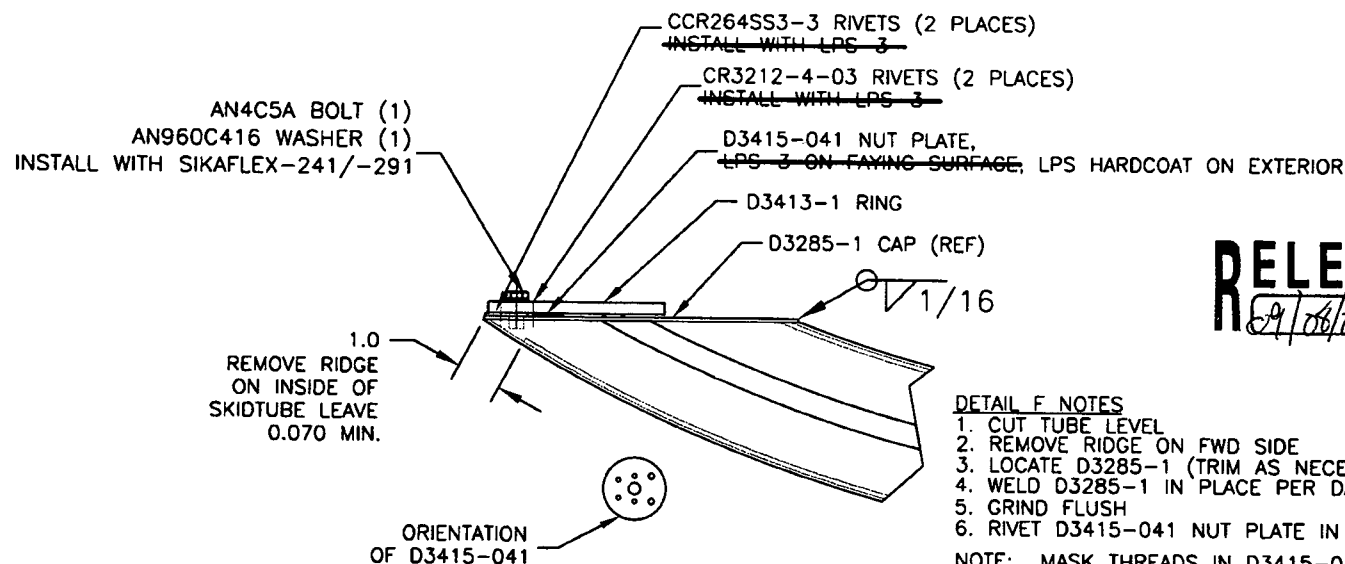
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

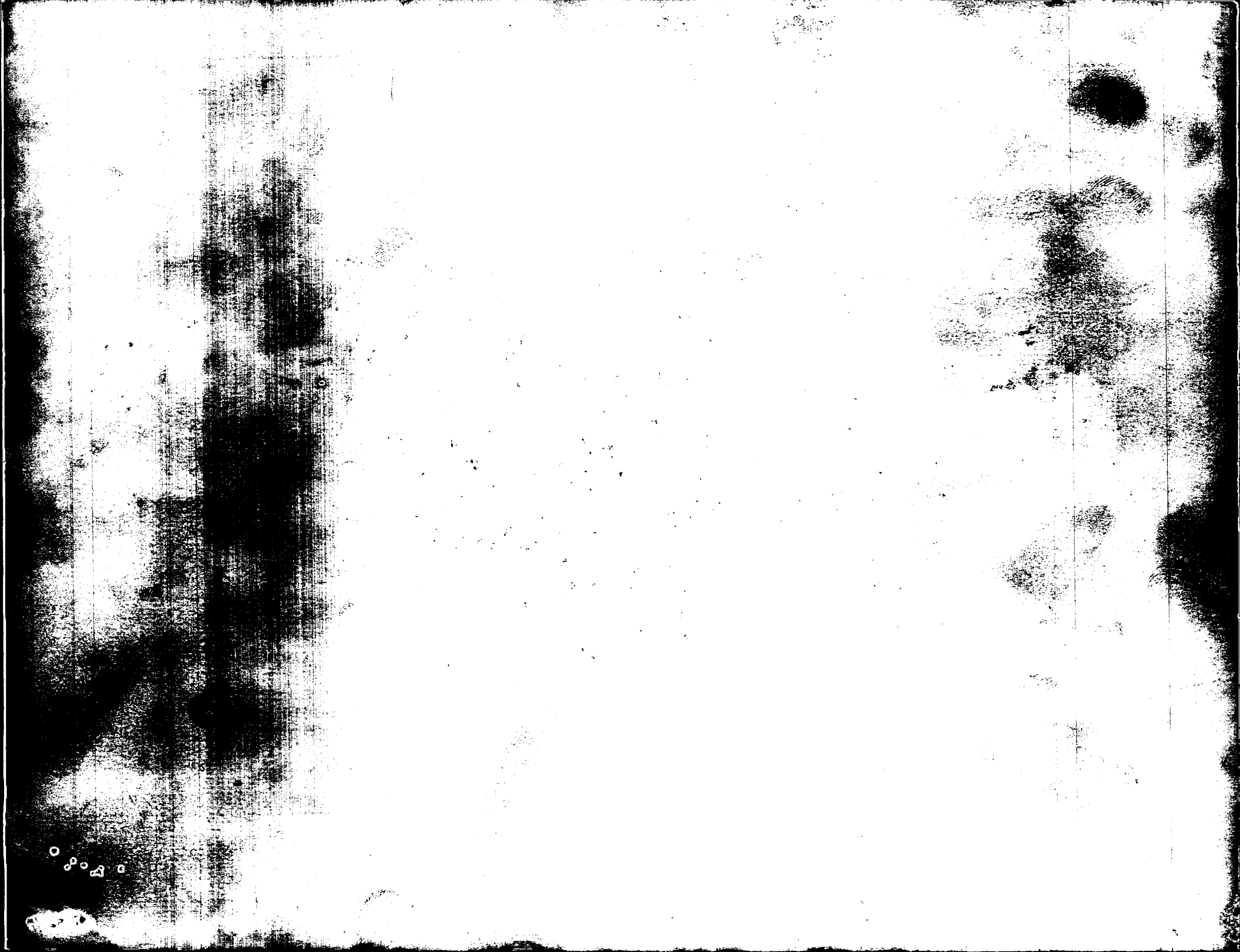
AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH



NO. 291

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 83400
Part number: A206-642-541
Description: Skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Alum.
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:

pass ☒ fail ☐

Penetration:

pass ☒ fail ☐

UNACCEPTABLE

Cracks:

pass ☒ fail ☐

Undercut:

pass ☒ fail ☐

Pin holes:

pass ☒ fail ☐

Overlap (cold lap)

pass ☒ fail ☐

Porosity (surface):

pass ☒ fail ☐

Coloration:

pass ☒ fail ☐

Qualifier David Kewal

Date of Test Coupon 12.04.26

Welder Barclay Elliott

Date of Test Coupon 12.04.26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld